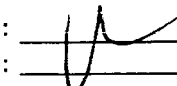


Date: Monday, 22/09/2008 3:38:02 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PANEL-350 FWD CANOPY
Job Number : 42209	
Estimate Number : 13099	
P.O. Number :	Part Number : D36563
This Issue : 22/09/2008 S.O. No. :	Drawing Number : D3656 REV A
Prsht Rev. : NC	Project Number : 00204
First Issue : 11 Type : THERMOFORMING	Drawing Revision : A <i>01-08.09.24</i> ①
Previous Run : 39711	Material :
Written By : 	Due Date : 26/09/2008 Qty: 1 <i>Um:</i> Each
Checked & Approved By :	
Comment : Est. Rev. A 07/12/13 DL verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
-----	-----------------	-------------------------



Comment: Qty.: 34.6600 sf(s)/Unit Total : 103.9800 sf(s)
 GE PLASTICS LEXAN SHEET
 batch: *M107574*

DL 08.09.24

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

DL 08.09.24

3.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-3 and Folio FTA 016 using tool DT8987

Dwg. Rev. 13.
 Folio Rev. 4.

DL 08.09.24

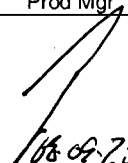
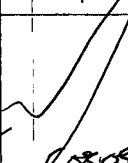
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

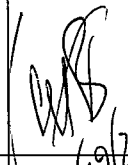


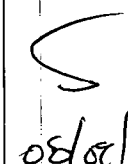
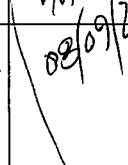

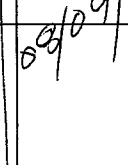
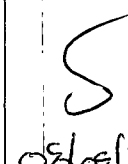

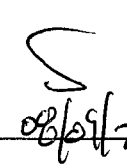

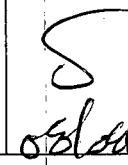
Visually inspect for proper formation of each part

DL 08.09.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.09.24	6.	Drawing revised. REV. B. so that skylight window panel is not trimmed out.	pl.	08.09.24		 08/09/25	 08/09/25

Part No: D3656-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.09.23	4	Mould blistered - leaving marks in mould Scrap 1 part.	 08/09/24	Repair Mould and replace part. Qty @ B# <u>107574</u>	pl. 08.09.23	 08/09/25	 08/09/25	 08/09/25
08.09.24	4.	Parts too hot webbing.	 08/09/24	Scrap 3 parts and tweak program, B# <u>107574</u> Qty (3)	pl. 08.09.24	 08/09/25	 08/09/25	 08/09/25
08.09.24	4.	Un-adequate vacuum part not formed	 08/09/24	Scrap 1 part and allow time between ports for vacuum buildup.	pl. 08.09.24	 08/09/25	 08/09/25	 08/09/25

NOTE: Date & initial all entries

B# 107574 Qty (1)

Date: Monday, 22/09/2008 3:38:02 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 FWD CANOPY

Job Number: 42209

Part Number: D36563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/09/25 (X)

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

08.09.24

1) Trim to Finished Dimensions as per dwg D3656

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08.09.24

Check dimensions to ensure conformity to drawing tolerances.

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/25 (X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 42207 8/9/25

54

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/25 (X)

Job Completion



MF 08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

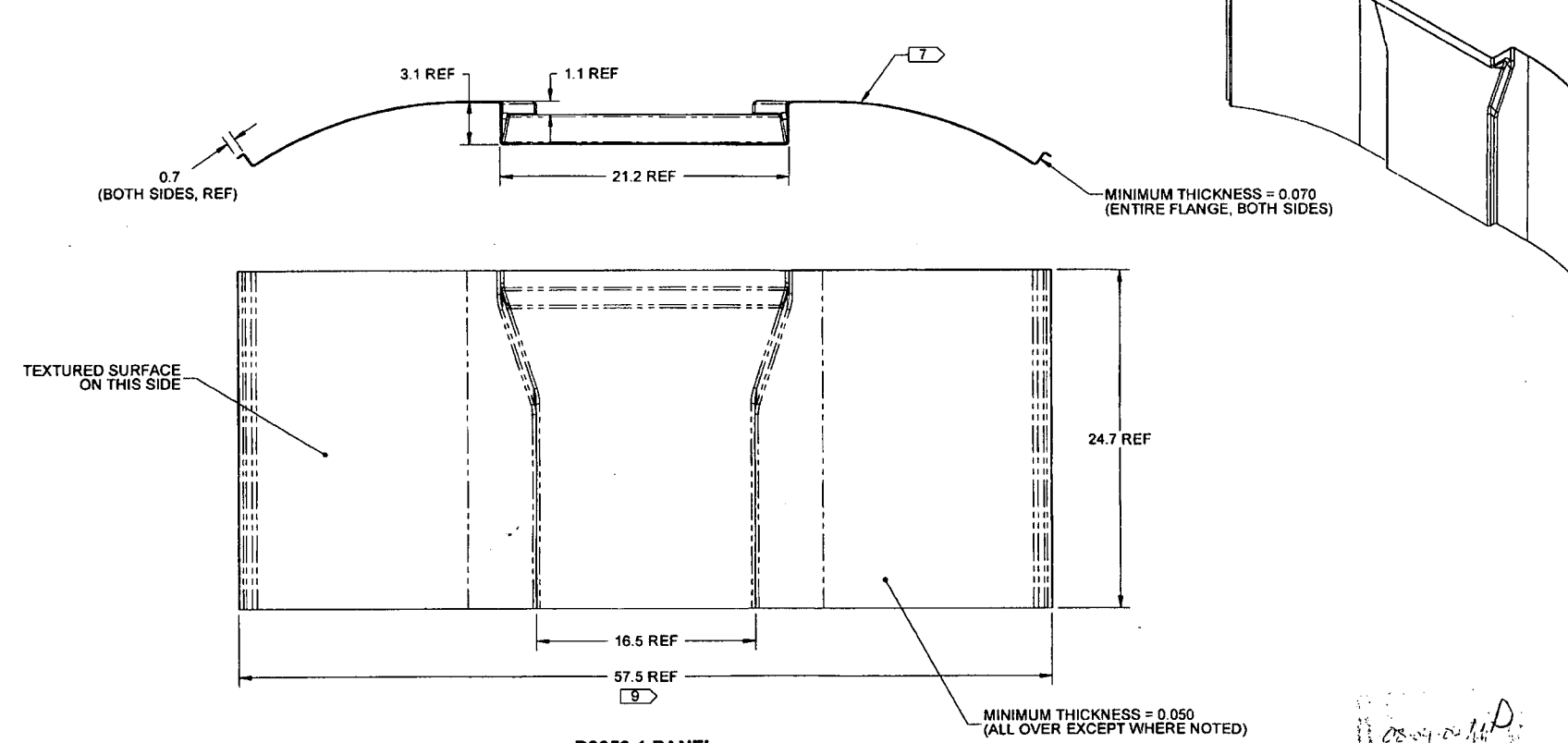
8 7 6 5 4 3 2 1

D

C

B

8 7 6 5 4 3 2 1



D3656-1 PANEL

Handwritten: 102209

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022 TRIM PER MOLD DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	LE	08.03.03
DESIGN	LE		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	LE		
APPROVED	LE		
DE APPR.	LE		
DATE	08.03.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3656	REV. A
TITLE PANEL	SHEET 1 OF 2
	SCALE NTS

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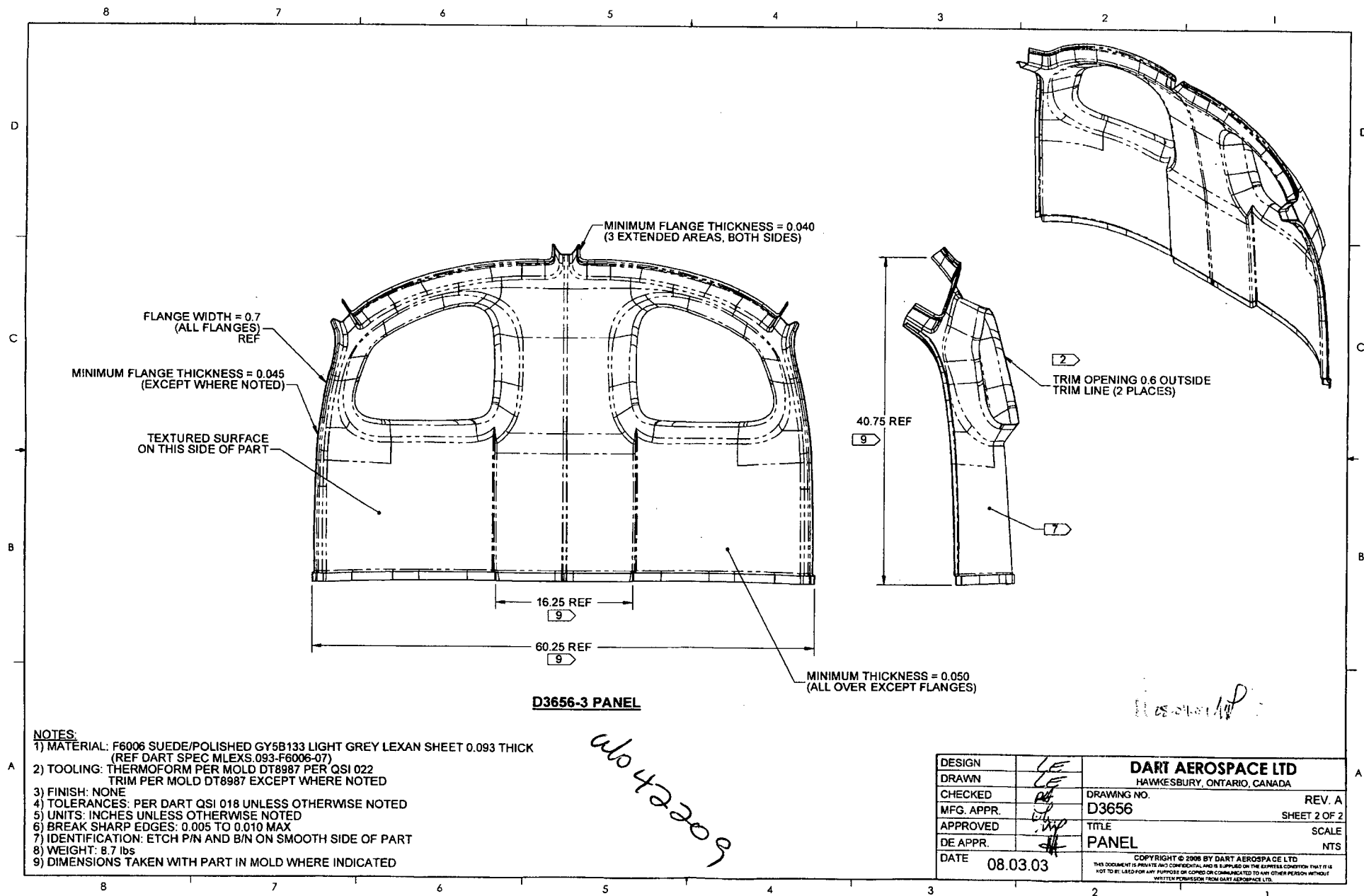
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	42209
Description: Panel		Part Number:	D3656-3
Inspection Dwg: D3656	Rev: A <i>OK A</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	<i>✓</i>			
Free of visual flaws (bumps, cracks, voids, etc.)	<i>✓</i>			

Measured by: *DK*

Date: *08.09.25*

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.040	Min	<i>0.042</i>	<i>✓</i>		<i>Depth</i>	
0.045	Min	<i>0.048</i>	<i>✓</i>		<i>Depth</i>	
0.050	Min	<i>0.071</i>	<i>✓</i>		<i>Depth</i>	

Measured by: *DK*

Date: *08.09.25*

Audited by: *E*

Date: *2/9/25*

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL <i>AK</i>	<i>DK</i>